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Hawkesbury, ON
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Tel (613) 632-5200
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D139-816-011
Job Sheet 185034



Part No: D139-816-011

Job Qty: 1 ea

Part Name: Lightweight Interior Ceiling Panels



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI9686 REV A , DSI9691 REV A , IIN-D139-816 REV D SHEET 27 IPP Rev A 12/05/07 New Release
DL IPP Rev. B 12/11/08 Update dwg. DL IPP Rev. C Dwg. Update 13/07/09 DL verf:DD IPP REV:D 13.12.23
AS PER IIN REV.D DD VERF:JFS IPP REV E 14.04.01 AS PER DSI9686 JLM VERIFIED BY:DD

Ship Via:

6916

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Stores/Pkg-1	6	NOV 29 2018
110	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging1-1 DAS	9-89	DEC 07 2018
120	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC4 69	DAS	
130	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-19-89	69	
135	DC	1 pcs	12/7/18	12/7/18	0.00	0.00	DC	9-89	DEC 07 2018
140	QC21-FG	1 Ea	12/7/18	12/7/18	0.00	0.00	QC21		DEC 07 2018

Part Op 130 - Package as per PPP D139-816-011 Identify and Stock Location: FG
Descriptions: 135 - Photocopy blue file & type labels as per PPP D139-816-011 CHG006

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2351-20-21-C3C	Stud	16 Ea (16 ea)	90-Start up Operation	5007845
50-009-2	Grommet	16 Ea (16 ea)	90-Start up Operation	5004860
AN970-3	Washer	10 Ea (10 ea)	90-Start up Operation	5082331
BT1.5I-M	Tie Wrap	24 Ea (24 ea)	90-Start up Operation	PM128238-1
BT3LH-L	Tie Wrap	12 Ea (12 ea)	90-Start up Operation	5034049
CB200	Acrylic Adhesive, 3.5G	3 pcs (3 ea)	90-Start up Operation	5130344
CS125-1032-8AACR	Stud	2 Ea (2 ea)	90-Start up Operation	PM130237
D4636-11	Bracket	10 Ea (10 ea)	90-Start up Operation	5004430
D4636-5	Bracket	16 Ea (16 ea)	90-Start up Operation	5122035
D4636-7	Retainer Plate	4 Ea (4 ea)	90-Start up Operation	5011127
D4636-9	Template	1 Ea (1 ea)	90-Start up Operation	5124315
D4648-1	Template	1 Ea (1 ea)	90-Start up Operation	5004067
D4653-041	Vent Manifold Assembly	6 Ea (6 ea)	90-Start up Operation	5041532
D4653-11	Clamp	6 Ea (6 ea)	90-Start up Operation	51547091 512540512
D4664-7	Spacer	3 Ea (3 ea)	90-Start up Operation	50610393
D4712-043	Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	50244848
D4716-1	Duct Hose	2 Ea (2 ea)	90-Start up Operation	5026828
D4716-3	Duct Hose	4 Ea (4 ea)	90-Start up Operation	5026832
D4716-5	Duct Hose	6 Ea (6 ea)	90-Start up Operation	5026830
D4728-057	Ps7J1 Jumper	1 Ea (1 ea)	90-Start up Operation	5047138
D4728-063	Cabin Temp Sensor Jumper Assembly	1 Ea (1 ea)	90-Start up Operation	5018428

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval _____																			
Description Work Order Deviation				Dispositio																					
Root Cause				FAULT CATEG																					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐																						
Design ☐	Operator ☐	Bending ☐	Set-up ☐																						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐																						
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐																						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualif ☐																						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐																						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐																						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐																						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐																						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐																						
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

DART AEROSPACE
 Container No: S133133
 Part: D139-816-011
 Job No: 185034
 Serial No/Batch: S133133
 Revision:
 Inspector:
 Exp Date:
 Instructions: TC STC SH12-54 Issue Date FA-STC SH032511

Completed By _____

Hand / Supervisor Approval Verification _____

QC / QA Coordinator Approval _____

Positioned Wrong ☐

Outside Dimensions ☐

Over/Under tolerance ☐

Part Incorrect ☐

Part Lost/Missing ☐

Part Moved ☐

Drawing ☐

Finish ☐

Misread ☐

Turning Sequence ☐

D4730-020-035	Velcro Strip 2.0W/ X 3.5L	24 Ea (24 ea)	90-Start up Operation	5126654
D5032-1	Doubler	16 Ea (16 ea)	90-Start up Operation	5003362
D5032-3	Doubler	16 Ea (16 ea)	90-Start up Operation	5003364
D5078-1	Bracket	1 Ea (1 ea)	90-Start up Operation	5012676
MS21042L3	Nut	35 Ea (35 ea)	90-Start up Operation	5094592
MS24694-S51	Screw	36 Ea (36 ea)	90-Start up Operation	5004858
MS27039-1-15	Screw	21 Ea (21 ea)	90-Start up Operation	5112435
NAS1149D0316J	Washer	5 Ea (5 ea)	90-Start up Operation	PM134502.2
NAS1149D0332J	Washer	34 Ea (34 ea)	90-Start up Operation	5132380
NAS1149D0663J	Washer	6 Ea (6 ea)	90-Start up Operation	5093376
D4634-041	Fwd, Center Ceiling Panel Assembly	1 Ea (1 ea)	110-Packaging	5134240
D4634-043	Middle, Center Ceiling Panel Assembly	1 Ea (1 ea)	110-Packaging	5134250
D4634-045	Aft, Center Ceiling Panel Assembly	1 Ea (1 ea)	110-Packaging	5135627
D4635-041	Fwd Ceiling Panel Assembly, LH	1 Ea (1 ea)	110-Packaging	5135599
D4635-042	Fwd Ceiling Panel Assembly, RH	1 Ea (1 ea)	110-Packaging	5135575
D4635-043	Aft Ceiling Panel Assembly, LH	1 Ea (1 ea)	110-Packaging	5134738
D4635-044	Aft Ceiling Panel Assembly, RH	1 Ea (1 ea)	110-Packaging	5134717
D4636-043	Receptacle Bracket Assembly	16 Ea (16 ea)	110-Packaging	5014402

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2351-20-21-C3C	16	59	0
	50-009-2	16	185	0
	AN970-3	10	193	0
	BT1.5I-M	24	474	0
	BT3LH-L	12	459	0
	CB200	3	16	0
	CS125-1032-8AACR	2	40	0
	D4636-11	10	39	0
	D4636-5	16	47	0
	D4636-7	4	17	0
	D4636-9	1	5	0
	D4648-1	1	9	0
	D4653-041	6	20	0
	D4653-11	6	12	0
	D4664-7	3	3	0
	D4712-043	2	12	0
	D4716-1	2	8	0
	D4716-3	4	16	0
	D4716-5	6	25	0
	D4728-057	1	3	0
	D4728-063	1	8	0
	D4730-020-035	24	52	0
	D5032-1	16	76	0
	D5032-3	16	79	0
	D5078-1	1	14	0
	MS21042L3	35	2,528	0
	MS24694-S51	36	113	0
	MS27039-1-15	21	369	0
	NAS1149D0316J	5	584	0
	NAS1149D0332J	34	2,070	0
	NAS1149D0663J	6	1,094	0
110-Packaging	D4634-041	1	0	0
	D4634-043	1	0	0
	D4634-045	1	0	0
	D4635-041	1	0	0
	D4635-042	1	1	0
	D4635-043	1	0	0
	D4635-044	1	0	0
	D4636-043	16	38	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS			
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D139-816-011	INTERIOR CEILING PANEL KIT
1	D4634-041	FWD, CENTER CEILING PANEL ASSEMBLY
1	D4634-141	* FWD, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4634-043	MIDDLE, CENTER CEILING PANEL ASSEMBLY
1	D4634-143	* MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4634-045	AFT, CENTER CEILING PANEL ASSEMBLY
1	D4634-145	* AFT, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-041	LH, FWD CEILING PANEL ASSEMBLY
1	D4635-141	* LH, FWD CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-042	RH, FWD CEILING PANEL ASSEMBLY
1	D4635-142	* RH, FWD CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-043	LH, AFT CEILING PANEL ASSEMBLY
1	D4635-143	* LH, AFT CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-044	RH, AFT CEILING PANEL ASSEMBLY
1	D4635-144	* RH, AFT CEILING REPLACEMENT PANEL ASSEMBLY
16	D4636-043	RECEPTACLE BRACKET ASSEMBLY
10	D4636-11	BRACKET
16	D4636-5	BRACKET
4	D4636-7	RETAINER PLATE
1	D4636-9	TEMPLATE
1	D4648-1	TEMPLATE
6	D4653-041	VENT MANIFOLD ASSEMBLY
6	D4653-11	CLAMP
3	D4664-7	SPACER
2	D4712-043	BRACKET ASSEMBLY
2	D4716-1	DUCT HOSE
4	D4716-3	DUCT HOSE
6	D4716-5	DUCT HOSE
1	D4728-057	HARNESS ASSEMBLY
1	D4728-063	HARNESS ASSEMBLY
24	D4730-020-035	VELCRO STRIP
16	D5032-1	DOUBLER
16	D5032-3	DOUBLER
16	2351-20-21-C3C	DZUS SCREW
16	50-009-2	GROMMET
10	AN970-3	WASHER
24	BT1.5I-M	TIE WRAP
12	BT3LH-L	TIE WRAP
3	CB 200	3.5g ACRYLIC ADHESIVE
2	CS125-1032-8-AA-CR	STUD (or CS125-1032-8-AA-CRM)
35	MS21042L3	NUT
36	MS24694-S51	SCREW
21	MS27039-1-15	SCREW
5	NAS1149D0316J	WASHER (or AN960JD10L)
34	NAS1149D0332J	WASHER (or AN960JD10)
6	NAS1149D0663J	WASHER (or AN960JD616)

NOTES:

(*) DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE
D4634-141/-143/-145 ARE REPLACEMENT PANELS
D4635-141/-142/-143/-144 ARE REPLACEMENT PANELS

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Revision: **D**
Date: 13.12.16

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54

REF. FAA STC: SR03251NY

REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide instructions to install the D5078-1 Bracket to support the Overhead Connector for D139-811-011 Interior Ceiling Panel Kit.

2.0 PROCEDURE

This procedure is added after step 3.1.39 of IIN-D139-816 Rev. D.

- 2.1 Position the D5078-1 Bracket on the LH side of the cabin overhead by temporarily removing 2x MS27039-1 screws as shown in Figure 1. Transfer 2x $\varnothing 0.204$ " (#6 drill) holes from airframe to the D5078-1 Bracket. Deburr and touch-up holes with MIL-P-85582 or MIL-P-23377 primer.
- 2.2 Install D5078-1 Bracket using existing 2x MS27039-1 screws and washers as shown in Figure 1.
- 2.3 Install overhead cannon plug in the D5078-1 Bracket using existing NAS1801/1802 screws and existing AS85049/95-20A-A Perimeter Mounting Flange as shown in Figure 2.
- 2.4 Reconnect wire harness to overhead cannon plug as shown in Figure 2.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

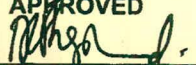
5.0 PARTS LIST

The D5078-1 bracket has been added to D139-816-011 Kits at CHG 005 and later. Customers who wish to obtain the D5078-1 Bracket for a kit that has already been installed can procure the DSI 9691-011 kit from Dart as outlined below.

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9691-011	BRACKET KIT
1	D5078-1	BRACKET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO #01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9691	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET INSTALLATION	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54

REF. FAA STC: SR03251NY

REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide an alternate method of installing the D139-816-011 Interior Ceiling Panel Kit for customers with newer 300 series aircraft models with split center ceiling panels.

2.0 PROCEDURE

This procedure modifies step 3.1.7 of IIN-D139-816 Rev. D.

- 2.1 Position the D4634-041/-043/-045 center panels onto the p/n E4417F01 cabin isolation mounts using $\varnothing 0.25"$ (6 mm) holes in the panels. Identify those mounts that do not align with holes in the panels. Ensure that a gap between the D4634-041/-043/-045 panels of approximately 0.050" (1.3 mm) is maintained.
- 2.2 Remove extra and non-aligning cabin isolation mounts from the ceiling. Temporarily install the removed mounts into non-align holes in the panels and paint mark the back of the E4417F01 mounts. Position the D4634-041/-043/-045 center panels onto p/n E4417F01 cabin isolation mounts. Ensure the new mount locations get marked in the cabin roof. Remove panels keeping the mounts on the panels.
- 2.3 Remove ceiling insulation from aircraft ceiling at the new marked mount locations.
- 2.4 Apply a small amount of CB 200 Click Bond adhesive to the E4417F01 cabin isolation mounts that are being relocated.
- 2.5 Reposition the ceiling panels on the ceiling pressing the E4417F01 cabin isolation mounts firmly on the ceiling and holding in position until the adhesive cures enough to remove the screws from the mount.
- 2.6 Install the necessary rivets to re-fasten the E4417F01 cabin isolation mounts to the ceiling.
- 2.7 Continue the ceiling panel installation as indicated in the IIN-D139-816.

3.0 GENERAL NOTE

- 3.1 Due to the thermoforming process variations in material thickness may occur. It is acceptable to install longer or shorter Dzus fasteners as required to accomodate this material variation.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

For D139-816-011 & CHG 005 and later, the following parts have been added to the kits.

QTY. -011	PART NUMBER	DESCRIPTION
X	D139-816-011	INTERIOR CEILING PANEL KIT
3	CB 200	3.5g ACRYLIC ADHESIVE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9686	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		ALTERNATE INSTALLATION	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Change Record

PAGE 1 OF 1

Part Number: D139-816-011

Description: INTERIOR CEILING PANEL

[illegible]

